

Work Order ID 60299

July 1, 2010 12:58:40 PM



Page 1

Item ID: DSK078

Accept



Setup Start



Revision ID:

Stop



Item Name: D2893-1 TURNING DETAIL

Start Date: 01/07/2010 Start Qty: 10.00



Cust Item ID:

Required Date: 29/07/2010 Req'd Qty: 10.00

Customer:

Reference:

Jul 10.07.01

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

DSK078

Rev A

100

0.00



MORI SEIKI CNC LATHE LARGE

Doosan

Memo

0.00

Doosan Lathe

Turn blank as per Folio FA081
(4TH AXIS PLUG DT8492)

SA 10/07/23

10 *φ*

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

SA 10/07/23

10 *φ*

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

SA 10/07/25

10 *φ*

Work Order ID 60299

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Item ID: DSK078

Accept



Setup Start



Revision ID:

Item Name: D2893-1 TURNING DETAIL

Stop



Start Date: 01/07/2010 Start Qty: 10.00



Cust Item ID:

Required Date: 29/07/2010 Req'd Qty: 10.00

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Packaging	0.00							
	Packaging					10	8		
Packaging	Memo	0.00							
	Identify and Stock in Kanban								
	Location: C.N.C								
	DSK078								
140	QC21- Final Inspection - Work Order Release	0.00							
	QC								
Quality Control	Memo	0.00							

10/07/26

u 10-07-26

Picklist Print

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Work Order ID: 60299



Parent Item: DSK078



Parent Item Name: D2893-1 TURNING DETAIL


Start Date: 01/07/2010

Required Date: 29/07/2010

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP rev A. 08.03.13 new issue EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6104-005  Round Billet, 17-4		Manufactured	No				Each	0.0000	1	10			



B 60387

10

SA 10/07/23

DART AEROSPACE LTD		Work Order: 60299
Description: Turning Detail for D2893-1		Part Number: DSK078
Inspection Dwg: DSK078	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article ☐ Prototype

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5
Lathe Section								
A	2.707	2.712		2.7085	2.707	2.708	2.708	2.709
B	4.946	4.966		4.960	4.962	4.961	4.962	4.962
C	3.064	3.084		3.075	3.075	3.075	3.075	3.075
D	0.718	0.738		.725	.729	.729	.729	.725
E	0.090	0.110		.103	.103	.103	.103	.103
F	2.934	2.954		2.945	2.945	2.946	2.945	2.945
G	2.166	2.186		2.183	2.177	2.177	2.177	2.177
H	3.890	3.910		3.902	3.902	3.903	3.902	3.902
I	0.914	0.934		.920	.920	.920	.920	.920
J	0.022	0.042		.030	.030	.030	.030	.030
K	0.109	0.129		.120	.120	.120	.120	.121
L								
M								
N								
O								
P								

Measured by: SA Date: 01/07/22

Audited by: Date:

Prototype Approval: Date:

Rev	Date	Change	Revised by	Approved
A	08.04.22	New Issue	KJ/JLM	

DART AEROSPACE LTD		Work Order:	60299
Description: Turning Detail for D2893-1		Part Number:	DSK078
Inspection Dwg: DSK078	Rev: A	Page 1 of 1	

FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article ☐ Prototype

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	16	17	18	19	110
Lathe Section								
A	2.707	2.712		2.709	2.707	2.709	2.709	2.709
B	4.946	4.966		4.962	4.962	4.962	4.963	4.962
C	3.064	3.084		3.075	3.075	3.075	3.075	3.075
D	0.718	0.738		.729	.729	.729	.729	.729
E	0.090	0.110		.103	.103	.103	.103	.103
F	2.934	2.954		2.945	2.945	2.945	2.945	2.945
G	2.166	2.186		2.177	2.177	2.177	2.177	2.177
H	3.890	3.910		3.901	3.901	3.902	3.901	3.902
I	0.914	0.934		.920	.920	.921	.920	.920
J	0.022	0.042		.030	.030	.030	.030	.030
K	0.109	0.129		.120	.119	.120	.120	.120
L								
M								
N								
O								
P								

Measured by: SA Date: 10/07/22

Audited by: Date:

Prototype Approval: Date:

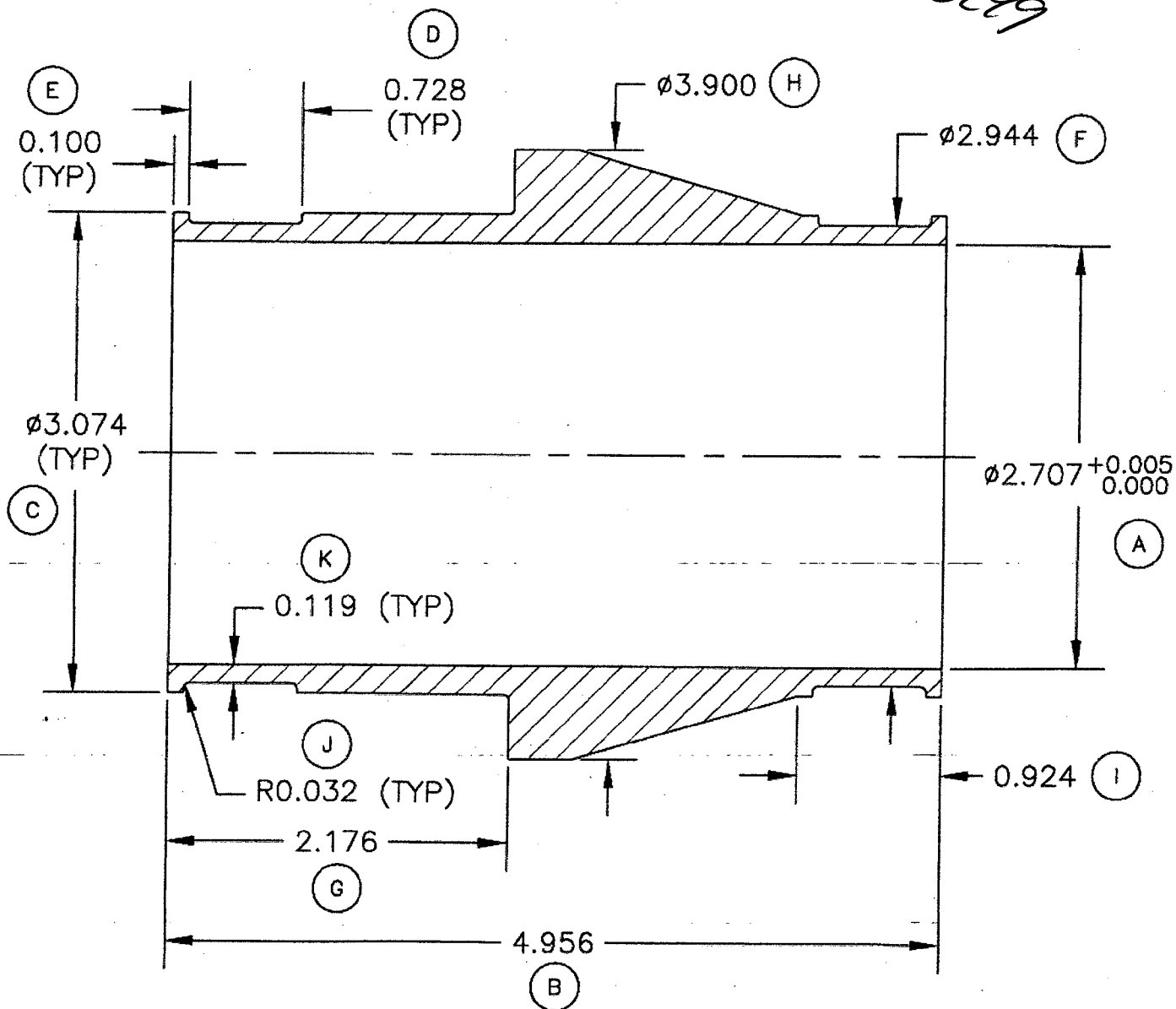
Rev	Date	Change	Revised by	Approved
A	08.04.22	New Issue	KJ/JLM	



DESIGN RT	DRAWN BY RT	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED H	APPROVED H	DRAWING NO. DSK 078	REV. A SHEET 1 OF 1
DATE 03.05.20		TITLE TURNING DETAIL FOR D2893-1	SCALE 1:1
A	03.05.20	NEW ISSUE	

RELEASED
03.07.01

4/0 60289



D2893-1 TURNING DETAIL

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